

Work Order ID 166295

Thursday, September 14, 2017 2:22:18 PM

166295

Page 1

Item ID: D2534 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Lock Plate
Start Date: 9/15/2017 Start Qty: 24.00 ***24*** Cust Item ID:
Required Date: 9/19/2017 Req'd Qty: 24.00 ***24*** Customer:
Reference:

Approvals: Process Plan: um Date: SEP 14 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2534	Rev D								

100

0.00

100

Waterjet

FLOW WATER JET

Memo

0.84

FLOW CNC Waterjet

1-Cut as per Dwg D2734 Dwg Rev: D Prog Rev: D 2-
Deburr if necessary

(24) 17/09/16 DA **DAS**
98 **40**
9-89

110

0.00

110

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.24

Quality Control

(24) 17/09/16 DA **DAS**
98 **40**
9-89

120

0.00

120

QC

QC8- Inspect parts - second check

Memo

0.48

Quality Control

24 DA **DAS**
SEP 18 2017 **9**
9-89

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>WA004</u>	0.00						SEP 18 2017	
130						<u>24</u>			<u>MLL</u>
Packaging	Memo	0.24							
Packaging	*****STOCK IN LARGE FAB***** LOCATION WA004								
140	QC21- Final Inspection - Work Order Release	0.00							
140									<u>17/9/20</u> <u>df</u>
QC	Memo	2.40							
Quality Control									

DAS
21
9-89

SEP 18 2017

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Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐							
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Picklist Print

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Page 1

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166295

Parent Item: D2534

D2534

Parent Item Name: Lock Plate

Start Date: 9/15/2017

Required Date: 9/19/2017

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP Rev:A New Issue 05-11-07 JLM
IPP Rev:B Now on Waterjet 06-06-20 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased		No		110	sf	72.9800	0.0427	1.078737			DAS 40 9-89
M304S11GA									**			17/09/16	
304/316 0.125 Sheet													

Location

Loc Qty

Loc Code

MAT020

72.98

M137110

0.82

M137599

8.16

M138109

32

M138346

32

11

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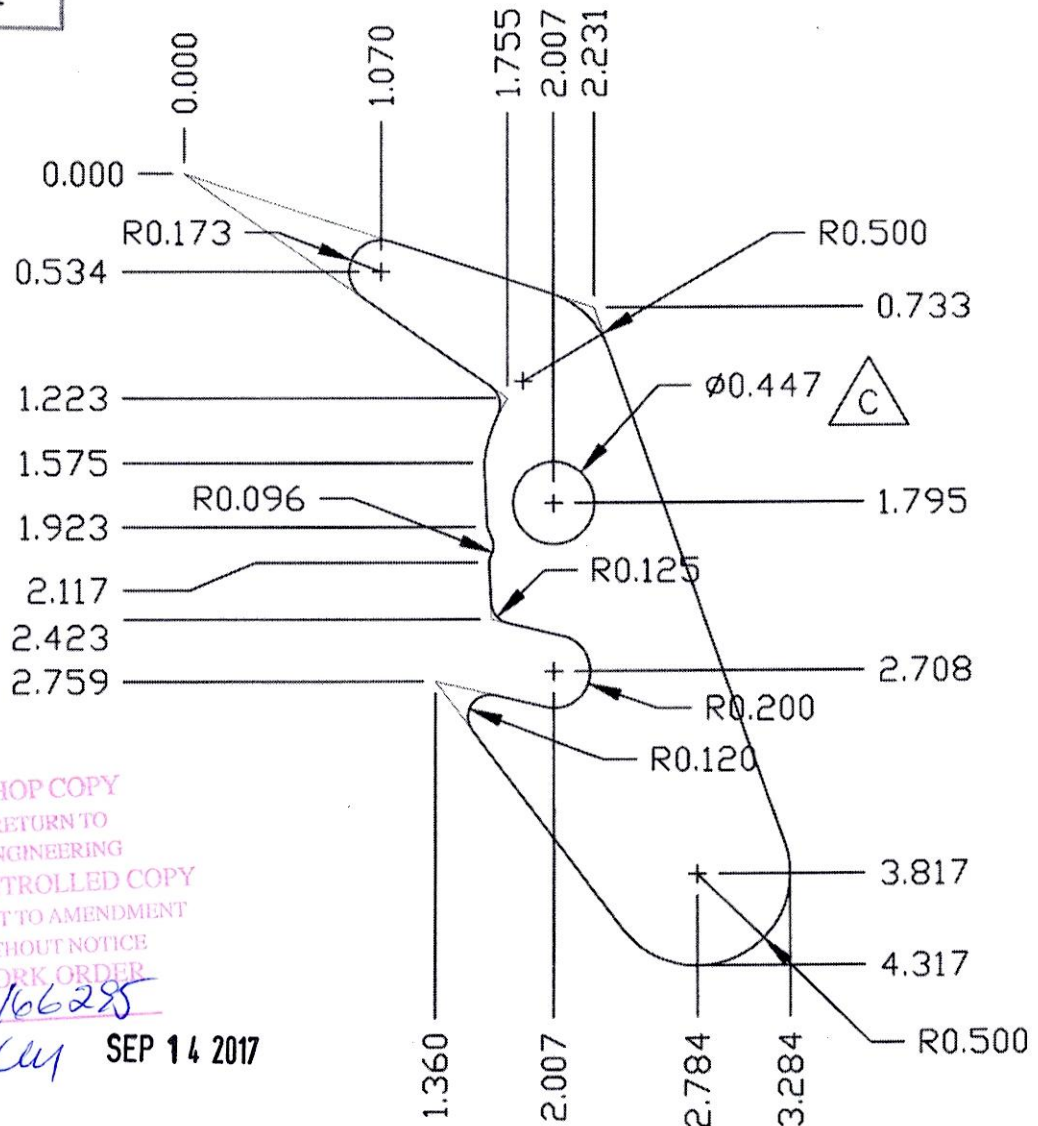
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DART

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	PH		
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2534	REV. D SHEET 1 OF 1
DATE 04.12.14	TITLE LOCK PLATE		SCALE 1:1
C	96.07.26	HOLE WAS 0.328	
D	04.12.14	UPDATE NOTES	

RELEASED04.12.16 *[Signature]*

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 166285

CM SEP 14 2017**D2534 LOCK PLATE**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 11 GAUGE (0.125 THICK)
(REF. DART SPEC. M304S11GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES TO 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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